

What is claimed is:

1. A nonaqueous electrolyte secondary cell comprising an electrode unit (2) encased in a battery can and comprising a positive electrode (23) and a negative electrode (21) each in the form of a strip and a separator (22) interposed between the electrodes, the cell being adapted to deliver electric power generated by the electrode unit (2) to the outside via a positive terminal portion and a negative terminal portion which are provided on the container, a negative electrode current collector plate (3) being joined to an edge of the negative electrode (21) projecting at one of opposite ends of the electrode unit (2) in the direction of winding axis thereof, the negative electrode current collector plate (3) being electrically connected to the negative terminal portion, the nonaqueous electrolyte secondary cell being characterized in that the negative electrode current collector plate (3) comprises a plurality of layers including a copper layer (31) made of copper or an alloy consisting predominantly of copper, and a metal layer made of a metal not forming an intermetallic compound with lithium and having a lower laser beam

reflectivity than copper or an alloy consisting predominantly of the metal, the copper layer (31) and the metal layer providing opposite surface layers of the collector plate (3), the copper layer (31) being
5 welded to the edge of the negative electrode (21).

2. A nonaqueous electrolyte secondary cell according to claim 1 wherein the metal forming the metal layer of the negative electrode current collector plate (3) is nickel.

10 3. A nonaqueous electrolyte secondary cell according to claim 1 wherein the metal forming the metal layer of the negative electrode current collector plate (3) is stainless steel.

4. A nonaqueous electrolyte secondary cell
15 according to claim 1 wherein the negative electrode current collector plate (3) is welded to the edge of the negative electrode (21) with a laser beam.

5. A nonaqueous electrolyte secondary cell according to claim 2 wherein the negative electrode
20 current collector plate (3) is welded to the edge of the negative electrode (21) with a laser beam.

6. A nonaqueous electrolyte secondary cell according to claim 3 wherein the negative electrode current collector plate (3) is welded to the edge of

the negative electrode (21) with a laser beam.

7. A nonaqueous electrolyte secondary cell according to claim 1 wherein the negative electrode current collector plate (3) has a thickness in the
5 range of 0.10 mm to 5.00 mm.

8. A nonaqueous electrolyte secondary cell according to claim 2 wherein the negative electrode current collector plate (3) has a thickness in the range of 0.10 mm to 5.00 mm.

10 9. A nonaqueous electrolyte secondary cell according to claim 3 wherein the negative electrode current collector plate (3) has a thickness in the range of 0.10 mm to 5.00 mm.

15 10. A nonaqueous electrolyte secondary cell according to claim 4 wherein the negative electrode current collector plate (3) has a thickness in the range of 0.10 mm to 5.00 mm.

20 11. A nonaqueous electrolyte secondary cell according to claim 5 wherein the negative electrode current collector plate (3) has a thickness in the range of 0.10 mm to 5.00 mm.

12. A nonaqueous electrolyte secondary cell according to claim 6 wherein the negative electrode current collector plate (3) has a thickness in the

range of 0.10 mm to 5.00 mm.

13. A nonaqueous electrolyte secondary cell according to claim 2 wherein the ratio of the thickness of the nickel layer (32) to the thickness of the negative electrode current collector plate (3) is in the range of at least 5% to not greater than 45%.

14. A nonaqueous electrolyte secondary cell according to claim 3 wherein the ratio of the thickness of the stainless steel layer (35) to the thickness of the negative electrode current collector plate (3) is in the range of at least 5% to not greater than 45%.